

Work Order ID 76806

76806

Page 1

Monday, November 21, 2011 11:24:54 AM

Item ID: D2662-25 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, RH In 206
 Start Date: 11/21/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 12/16/2011 Req'd Qty: 8.00 ***8*** Customer:

Reference:

Approvals: Process Plan: Date: 11-11-21 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2662	Rev E

100 0.00

100 HAAS CNC VERTICAL MACHINING #1 20 11.12.17 8 0

HAAS 1 Memo 0.00

HAAS CNC vertical machine #1 Program part number and batch number.
 Inspect part number and batch number are programmed

MACHINE AS PER FOLIO FB069 & DWG

DWG REV: E

FOLIO REV: AA

110 0.00

110 CONVENTIONAL MILLING MACHINE 20 11.12.17 8 0

Mill Conv Memo 0.00

Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Hand Finishing

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Work Order ID 76806

76806

Page 3

Monday, November 21, 2011 11:24:54 AM

Item ID: D2662-2 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Saddle, RH In 206
Start Date: 11/21/2011 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 12/16/2011 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:30								
	FINISH TIME: 10:00								
	32001								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 435	0.00							
170									
Packaging	Memo	0.00							
Packaging									

8X0M-11/12/20

8 BL 11-12-20

11/12/21, 11/80

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 76806***76806***

Page 4

Monday, November 21, 2011 11:24:55 AM

Item ID: D2662-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH In 206

Start Date: 11/21/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/16/2011 Req'd Qty: 8.00

8

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

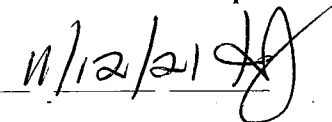
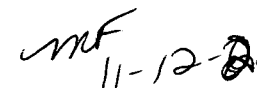
180

QC

Memo

0.00

Quality Control

11/12/21 MF 11-12-21 

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Picklist Print

Monday, November 21, 2011 11:24:58 AM

Page 1

Work Order ID: 76806

76806

Parent Item: D2662-2

D2662-2

Parent Item Name: Saddle, RH In 206

Start Date: 11/21/2011

Required Date: 12/16/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	152.0000	1	8			
D6101-001									**				
Saddle Billet													

Location	Loc Qty	Loc Code
MAT040	152	
66965	1	
69677	2	
73774	60	
74648	21	
74679	68	
→ 76836		

8.0

MA 11/12/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD	Work Order: 76804
Description: 206 Saddle, Inboard, Right side	Part Number: D2662-2
Inspection Dwg: D2662 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140	.125	.125	.125	.125	.125	.125	.125
B	0.100	0.140	.135	.135	.135	.135	.135	.135	.135
C	1.125	1.145	1.139	1.139	1.136	1.136	1.136	1.136	1.136
D	0.615	0.685	.685	.685	.685	.685	.685	.685	.685
E	0.240	0.260	.245	.245	.245	.245	.245	.245	.245
F	1.313	1.343	1.325	1.325	1.325	1.325	1.325	1.325	1.325
G	0.210	0.230	.218	.218	.218	.218	.218	.218	.218
H	0.100	0.180	.135	.135	.135	.135	.135	.135	.135
I	2.470	2.510	2.490	2.490	2.490	2.490	2.490	2.490	2.490
J	1.565	1.585	1.579	1.579	1.576	1.576	1.576	1.576	1.576
K	0.235	0.240	.237	.237	.237	.237	.237	.237	.237
L	0.100	0.120	.109	.109	.109	.109	.109	.109	.109
M	0.990	1.010	.998	.998	.998	.998	.998	.998	.998
N	0.510	0.515	.512	.512	.512	.512	.512	.512	.512
O	5.990	6.010	6.000	6.000	6.000	6.000	6.000	6.000	6.000
P	1.245	1.255	1.250	1.250	1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505	2.500	2.500	2.500	2.500	2.500	2.500	2.500
R	0.313	0.318	.313	.313	.313	.313	.313	.313	.313
S	0.315	0.322	.316	.316	.316	.316	.316	.316	.316
T	2.495	2.505	2.500	2.500	2.500	2.500	2.500	2.500	2.500
U	1.357	1.367	1.362	1.362	1.362	1.362	1.362	1.362	1.362
V	0.787	0.807	.797	.797	.797	.797	.797	.797	.797
W	0.540	0.560	.548	.548	.548	.548	.548	.548	.548
X	1.674	1.684	1.679	1.679	1.679	1.679	1.679	1.679	1.679
Y	0.257	0.262	.257	.257	.257	.257	.257	.257	.257
Z	0.912	0.932	.920	.920	.920	.920	.920	.920	.920
AA	0.490	0.510	.50	.50	.50	.50	.50	.50	.50
AB	0.178	0.198	.188	.188	.188	.188	.188	.188	.188
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>22</u>
Date: <u>11.12.17</u>

Audited by: <u>B.A</u>
Date: <u>11/12/19</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

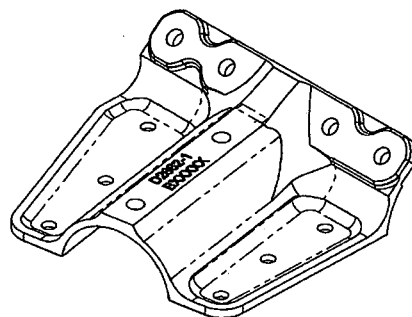
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

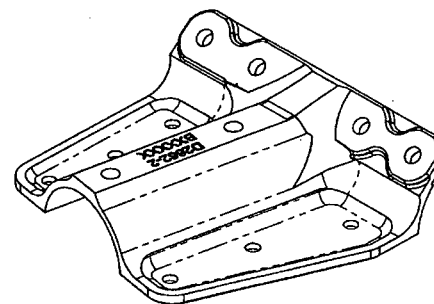
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NOTE: Date & initial all entries



D2662-1 SADDLE, INSIDE, LH



D2662-2 SADDLE, INSIDE, RH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO A REVISION
WITHOUT NOTICE
WORK ORDER NO. 76806

RII-11-21

RELEASED
2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4), REF INC 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP DEO 9122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>GP</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>GP</i>	KENT, WA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>GP</i>	D2662	SHEET 1 OF 5
APPROVED	<i>GP</i>	TITLE	SCALE
DE APPR.	<i>GP</i>	SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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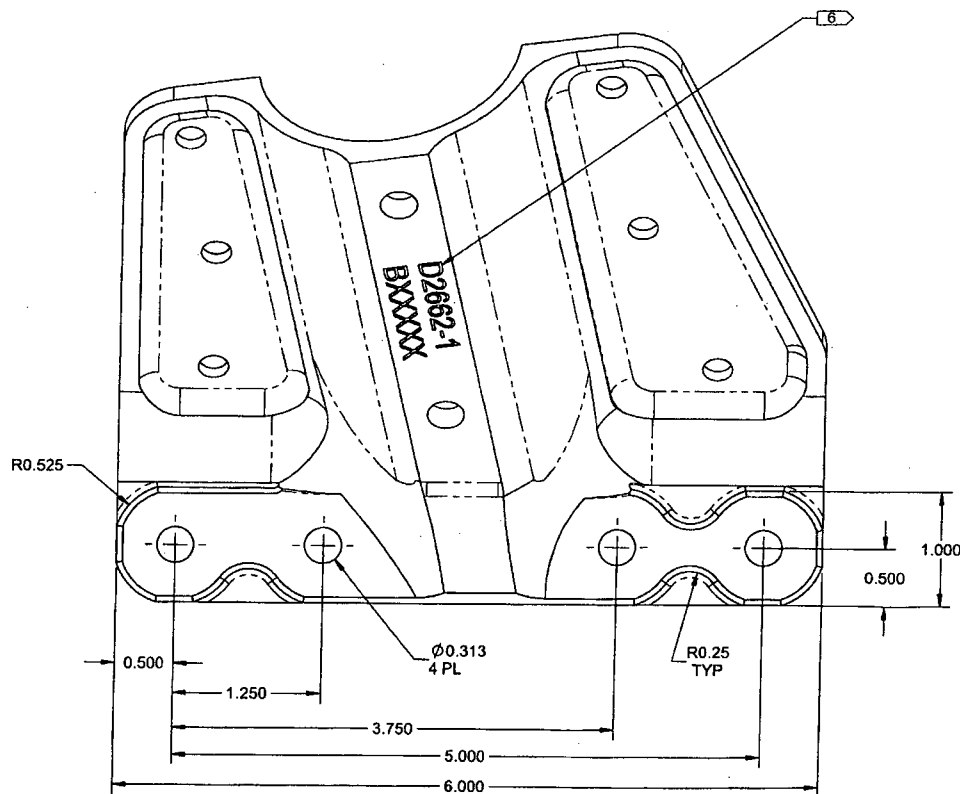
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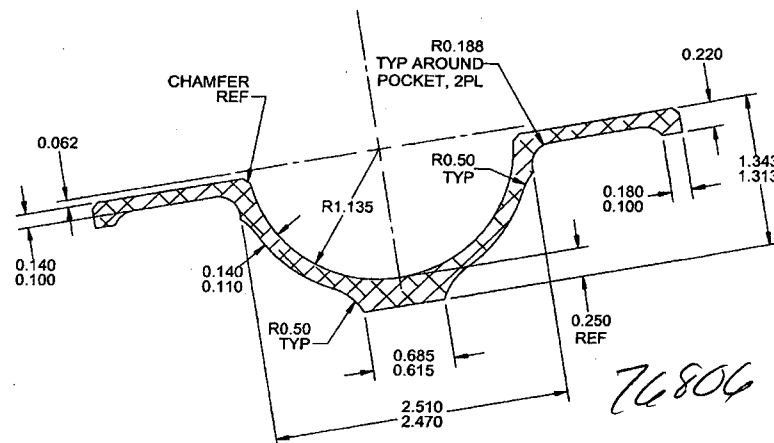
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VIEW B-B
SCALE 1.5X B4-2
VIEW ROTATED



VIEW A-A C1-2
SCALE 1.5X

RELEASED
2011-11-16
MD

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	90	KENT, WA	
CHECKED	ABS	DRAWING NO.	REV. E
MFG. APPR.	3/16	D2662	SHEET 3 OF 5
APPROVED	3/16	TITLE	SCALE
DE APPR.	3/16	SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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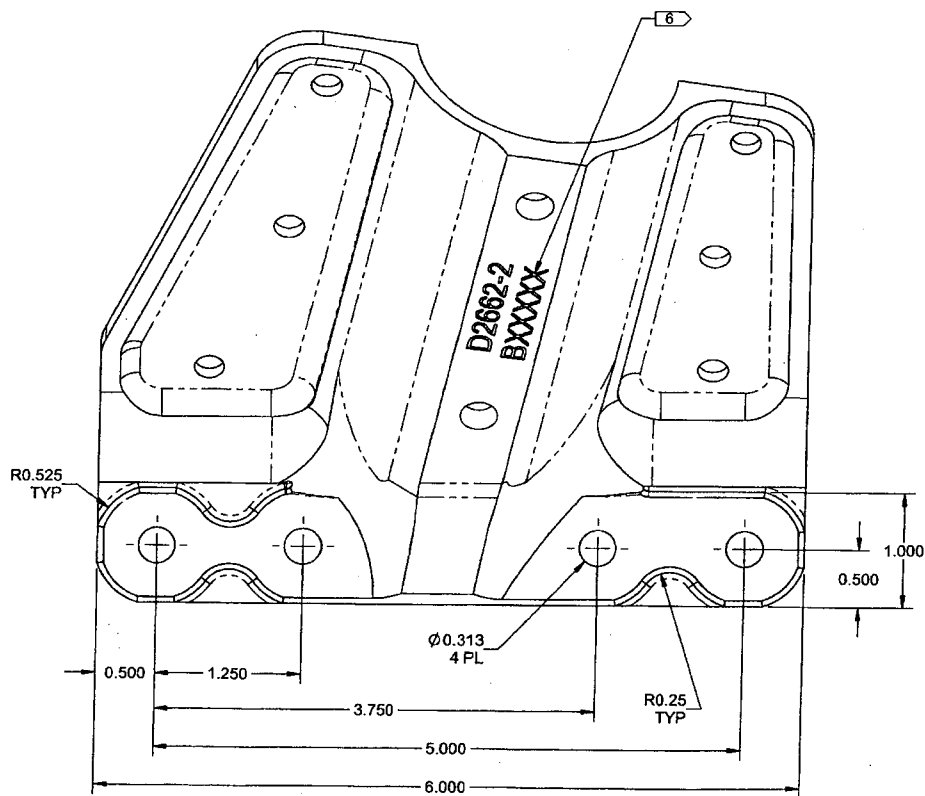
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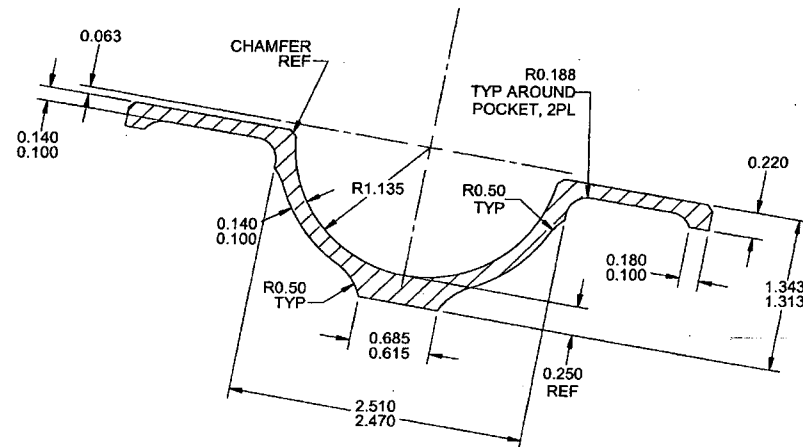
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NOTE: Date & initial all entries









VIEW D-D
SCALE 1.5X B4-4
VIEW ROTATED



VIEW C-C
SCALE 1.5X C3-4

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
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